Work Order Wednesday, Januar	ID 95672 y 16, 2013 12:56:31 PM		*9567	′2*			K) NOV	Page 1
Revision ID:	ck Plate Locator Brackets		Accept	N 900040	100)*	Setup Sta	1 7	S1*
Start Date: 1/1 Required Date: 1/3 Reference:	16/2013 Start Qty: 14.00 B1/2013 Req'd Qty: 14.00	*14* *14*		Cust Item ID: Customer:				14	
	rocess Plan: WWF	Date: \3-1-16	Tooling: SPC (Y/N):	Date:			Run Sta	!/	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/	Tool ID Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr			**************************************					
D2369	Rev A								
*100 *100* Waterjet FLOW CNC Waterjet	FLOW WATER JET Memo I-Cut as per I Deburr if nece	Dwg D2369 Dwg Rev:_ essary	0.00 0.00 Prog Rev:	2-	. <u> </u>	18	Õ		Jm13-2-1
5052 . 040 110 *110* QC Quality Control	QC2- Inspect parts off mad	chine FAI/FAIB	0.00			. (8	<u> </u>	···· ·- · · · · · · · · · · · · · · · ·	JM13.2-1
120 *120* QC Quality Control	QC8- Inspect parts - secon Memo	d check	0.00 13.d-Y			13.	1		
							PI	U	

NCR:	Yes)/	No

WORK ORDER NON-CONFORMANCE / UPDATE

1 -	•
DQA: W Date:	*
13/02/07	a [*]
Closed: Date:	

										QA Closed:	Date:	1/
Work Order:	9:	567	19		DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	'
Part No. <u>D2369-1</u> NCR No. <u>13-22913</u>				Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Small Fab Finishing	Proc Rec/Stor	Engineering Quality Other		
Root				Descri	ption of work order update	Initia	al	Action		Sign &		
Cause	Date	Step	Qty	,	or Non-conformance	Chief E	Eng	Description	on	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	13. 2-1)Y	•	1	deb	xtop, pand bond he pans processions by home	749 16 9-8 Q 200 1312	42	Destrated Los on esta	parl	702/04	A9 15 13, 3. 4	0AS 16 2-63 Q>2042 13/2/4
Onapproved		L	L	L	F	AULT C	ATEC	ORY				
Landing	Gear Bending Centre No	ot Conce	ntric to	o/s	General Bend BOM/Route	Gra				Ovalized Over/Under	tolerance	Pressure/Forced Temperature/Cure
	Cracks Crushed/	Crimped			Broken/Damaged Burrs	Inst	tructi	on Incomplete ions Incomplete/Uncl nance	ear	Part Incorred Part Lost/Mi Part Moved		Weld Wrong Stock Pulled
-	Heat Treat		Contamination Countersink Cut Too Short	Mis	slabe sread	led		Positioned V	Surge X	Other		
	Ripples in	•		,	Drill Holes	Off			L	OPERAT	ION / IMPR	OPER EQUIPMENT
	Torque V		Extrusio	on	Drawing	Out of Calibration						
	Turning S				Finish	Ou	t of S	equence				
	Wave/Tv	vist in Tu	be		Folio	Ou	tside	Dimensions				

Quality Control

Page 2

Wednesday, January 16, 2013 12:56:31 PM D2369-1 Item ID: Accept *N900040100* Setup Start **Revision ID:** Item Name: Deck Plate Locator Brackets Stop 1/16/2013 Start Date: **Start Oty: 14.00** *14* Cust Item ID: Required Date: 1/31/2013 Reg'd Otv: 14.00 **Customer:** Reference: Run Approvals: Process Plan: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Reject Plan Reject Accept Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 130 Identify as per dwg & Stock Location: 0.00 *120* Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 QC 0.00 Memo

Q113024

DQA:

Date:

NCR: Ye	es / No				WORK ORDER NON-	CONF	ORN	//ANCE / UP	DATE			*
										QA Closed:	Date	e:
Work Order					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Order	Part No. NCR No. Ot Date Step Qty ata Cooling Cor			· · · · · · · · · · · · · · · · · · ·	Rework	7		Skid-tube	Crosstube	1	Water Jet	Engineering
Part No	o .				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	 7	Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR No	o				Work Order Update]		Large Fab	Composite]	Supplier	
Root		[Descri	ption of work order update	Init	tial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief	f Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data												
quip/Tooling		ļ									:	
Operator												
Material												
etup												
Other												
rocess		İ									ļ	
Supplier												
Training	_											
Jnapproved	,	ļ									<u> </u>	
· · · · · ·						FAULT (CATE	GORY				
Landin	g Gear			_	General				F	.	ŗ	¬
_	→ *			<u> </u>	Bend	<u> </u>	rain		<u> </u>	Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to (o/s	BOM/Route		ardwa			Over/Under		Temperature/Cure
1				ļ	Broken/Damaged	<u> </u>		on Incomplete	, , <u> </u>	Part Incorre	F-	Weld
		'Crimped		ļ	Burrs			ions Incomplete	/Unclear	Part Lost/M	issing [Wrong Stock Pulled
				_	Contamination	\vdash		enance		Part Moved		
	—			_	Countersink		1islabe		<u> </u>	Positioned V		¬
	-	-	Tube	L	Cut Too Short		1isreac	d	L	Power Loss/	'Surge	Other
				L	Drill Holes		ffset					·
	Torque V	Vaves in	Extrusio	n L	Drawing	\vdash		Calibration				
	Turning S	Sequence	!		Finish	_		Sequence				
	Wave/Tv	vist in Tu	be		Folio	0	utside	Dimensions				

95672

Parent Item:

D2369-1

Parent Item Name:

Deck Plate Locator Brackets

Start Date: 1/16/2013

Required Date: 1/31/2013

Page 1

Start Qty: 14.00

Required Qty: 14.00

Comments:

IPP Rev A IPP Rev:B

Removed from 9 Digit 05-12-05 JLM now water iet

07-12-11 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040 5052-H32 .040 Sheet		Purchased	No			100	sf	101.7789	1.354	19.953684 2.32	25 T JAN, 1885.	LETTER TO BE	JM13-2-1

Location Loc Qty Loc Code MAT022 101.778945 119384 45.578945 122406 56.2

124445

124445

WORK ORDER NON-CONFORMANCE / UPDATE NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS DISPOSITION** Work Order: Water Jet Engineering Skid-tube Crosstube Rework Prod. Eng. Coor. Small Fab Scrap Machining Part No. Rec/Store/Packaging Thermoforming Finishing Use-as-is Supplier Composite Work Order Update Large Fab NCR No. Action Sign & Description of work order update Initial Root Chief Eng Description Date Verification Qty or Non-conformance Date Step Cause Doc/Data Equip/Tooling Operator

Landin	- g (Gear	General	_		•	_	•
ſ		Bending	Bend	Grain		Ovalized	L	Pressure/Forced
Ī		Centre Not Concentric to O/S	BOM/Route	Hardware:		Over/Under tolerance	\perp	Temperature/Cure
Γ		Cracks	Broken/Damaged	Inspection Incomplete	<u></u>	Part Incorrect	\perp	Weld
Γ		Crushed/Crimped	Burrs	Instructions Incomplete/Unclear		Part Lost/Missing	L	Wrong Stock Pulled
		Cuffs	Contamination	Maintenance	L	Part Moved		
		Heat Treat	Countersink	Mislabeled		Positioned Wrong	_	-
ſ		Inspection Strip in Tube	Cut Too Short	Misread	L	Power Loss/Surge	L	Other
		Ripples in Bend	Drill Holes	Offset				
		Torque Waves in Extrusion	Drawing	Out of Calibration				
		Turning Sequence	Finish	Out of Sequence				
		Wave/Twist in Tube	Folio	Outside Dimensions				

FAULT CATEGORY

DQA:

Date:

Quality

Other

QC Inspector

Material Setup Other Process Supplier Training Unapproved

DART AEROSPACE LTD	Work Order:	95670
Description: Deck Plate Locator Bracket	Part Number:	D2369-1
Inspection Dwg: D2369 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	x	First Artic	le	Proto	type
Drawing	Toloronoo	Actual	Assent	Baiast	Metho

Drawing	Toloronos	Actual	A	Doinet	Method of	0
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
0.500	+/-0.010	0,503"	-		V	Jtmo &
4.500	+/-0.010	4.504	_		V	
1.000	+/-0.010	1.007"	_		V	
5.709	+/-0.010	5.7.3"	-		V	
37.996	+/-0.010	37.996"	_		T	Jemao
38.297	+/-0.010	38.297"	-		7	
5.000	+/-0.010	5.003"	-		V	
4.451	+/-0.010	4.455"			~	
0.549	+/-0.010	Q 553''	_		V	
Ø0.191	+0.005/-0.000	0.192"	_		V	
Ø0.128	+0.005/-0.000	0.128"	1		Y	
39.000	+/-0.010	39,000	1		+	
38.544	+/-0.010	38.544	1		7	
					,	

Measured by: Jm	Audited by:	Prototype Approval:	N/A
Date: 13-2-1	Date: 13 5°4	Date:	N/A

Rev	Date	Change		Revised by	Approyed
Α	04.06.25	New Issue	P/O D350-616-015	KJ/JLM of	911

NCR:	Yes /	No	WORK	ORDER

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

NCR. 1	es / 140				WORK ORDER ROIN		. 01111	MAILUE / O.		QA Closed:	Date	::
Work Orde	r:		· · · · · · · · · · · · · · · · · · ·		DISPOSITION Rework	AGAINST DEPARTMENT/PROCESS Skid-tube Crosstube Water Jet Engineering						
Part N	lo				Scrap	1	r	Machining	Small Fab Finishing		d. Eng. Coor.	Quality Other
NCR N	lo				Use-as-is Work Order Update]		Large Fab	Composite	Nec/Stol	Supplier	
Root				Descri	ption of work order update	Ir	nitial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling							1					i ·
Operator	_	!										
Material						1	i					
Setup												
Other						1						,
Process						1						
Supplier											1	
Training						l					}	
Unapproved		<u> </u>						<u> </u>		<u> </u>		
						FAUL	T CATE	GORY				
Landi	ng Gear				General					1	Г	Pressure/Forced
	Bending			. -	Bend		Grain		<u> </u>	Ovalized	1	-
		ot Conce	ntric to (D/S _	BOM/Route	-	Hardware		<u> </u>	Over/Under	ļ	Temperature/Cure
	Cracks				Broken/Damaged			ion Incomplete	<i></i>	Part Incorre	<u> </u>	Weld
	─ ──	/Crimped		<u> </u>	Burrs	-	l	tions Incomplete/	/Unclear	Part Lost/M		Wrong Stock Pulled
	Cuffs				Contamination	—		enance 	<u> </u>	Part Moved		
	Heat Tre			 	Countersink	-	Mislabe		<u> </u>	Positioned V	· ·	7045
	—	on Strip ir	Tube	L	Cut Too Short	_	Misread	d		Power Loss/	Surge _	Other
	Ripples i			$oxedsymbol{\perp}$	Drill Holes	-	Offset	- III .:				
		Waves in		Դ _	Drawing		i -	Calibration				
		Sequence		L	Finish	_	i	Sequence				
Ĺ	Wave/T	wist in Tu	be	l	Folio	- [Outside	e Dimensions				

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D2369
-

SHEET 1 OF 2

SCALE

DECK PLATE LOCATOR BRACKET

95:02:20

37.996 38.297 1.000 5.709 — ø0.128 (4 PLACES) - 5.000 - 4.451 4.500 ∇ FWD 0.500 -- 0.549 0.000 Ø0.191 (2) 0.000 38.544 LABEL (D2364 UP)

D2369-1

MATERIAL: 5052-H34 0.040 THICK

Copyright 1995 by DART AEROSPACE LTD

			DQA:	 Date:	 	
 .,	,	 MADE OPPED NON CONFORMANCE / LIDDATE				

NCK. 1	162	/ NO				AAOUK OKDEK HOIA-K	COIN		MAINCE / OI		QA Closed:	Date:		
Work Orde	er: _					DISPOSITION		AGAINST DEPARTMENT/PROCESS Skid-tube Crosstube Water Jet Engineering						
Part No.						Rework Skid-tu Scrap Machin Use-as-is Thermoform				Crosstube Small Fab Finishing		d. Eng. Coor.	Quality Other	
NCR N	۱o					Work Order Update	<u> </u>		Large Fab	Composite		Supplier		
Root					Descri	ption of work order update	ln	itial	Ac	tion	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Chie	ef Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data														
Equip/Tooling			-		:							•		
Operator														
Material		٠								•		,		
Setup													1	
Other	Ш		·				1							
Process	Ш													
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Unapproved		·	<u> </u>									L		
							AULI	CATE	GORY					
Landi	_				_	General ¬₋.		. .		<u> </u>	ام داد دا	[_	Pressure/Forced	
	-	Bending			_	Bend	\vdash	Grain		<u> </u>	Ovalized		Temperature/Cure	
	Centre Not Concentric to O/S				o/s	BOM/Route		Hardwa		-	Over/Under Part Incorre	 	Weld	
	Cracks				<u> </u>	Broken/Damaged	\vdash	Inspection Incomplete			4		Wrong Stock Pulled	
	Crushed/Crimped Burrs				╡			ions Incomplete	Unclear	Part Lost/M	- <u>-</u>	Twitong Stock Fulled		
	-	Cuffs				Contamination	-		enance	<u> </u>	Part Moved			
	Heat Treat					Countersink	\vdash	Mislabe		<u> </u>	Positioned V	_	Other	
		Inspectio		Tube	<u> </u>	Cut Too Short		Misread	1	<u> </u>	Power Loss/	onige	Tomer	
	-	Ripples in			<u> </u>	Drill Holes	-	Offset	Californation					
	\vdash	Torque W			n	Drawing	 		Calibration					
	_	Turning S	-		<u> </u>	Finish	-		Sequence					
	Wave/Twist in Tube					Folio		Outside	Dimensions					

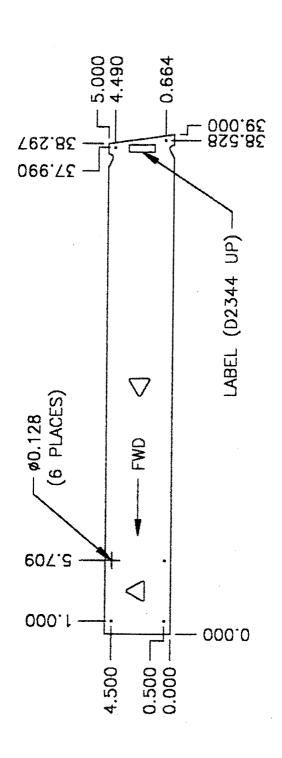
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	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV.	Ä
53W	4	D2369 . SHEET	2 OF	2
DATE	7	TILE	SCA	E
95:02:20		DECK PLATE LOCATOR BRACKETS	1	:7

RELEASED 96 06 10



D2369-3 MATERIAL: 5052-H34 0.040 THICK

											DQA.	Date.	
NCR: Yes / No						WORK ORDER NON-C	NFORN	QA Closed:	Date:	3			
Work Ordo			<u>-</u>			DISPOSITION				AGAINST DE			
Work Order: Part No. NCR No.						Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Prod Rec/Stor	Engineering Quality Other	
Root					Descri	ption of work order update	I	Initial	Acti	ion	Sign &		
Cause		Date	Step	Qty	•	or Non-conformance	Ch	nief Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						·							
							AUI	LT CATE	GORY				·
Landi	ding Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube					General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread			Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	
	Ripples in Bend					Drill Holes	Г	Offset					<u> </u>

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drawing

Finish

Folio

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